

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77830

December-21-11 3:43:01 PM

77830

Page 2

Item ID: D3183-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearing Assembly
 Start Date: 21/12/2011 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 *150* Packaging	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00							

Signature 12/01/16 (30)

count
(x30)

8/10/17

8-236

(30x) 12-01-19

W/O:		WORK ORDER CHANGES					
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December-21-11 3:43:01 PM

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/21/11
30

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Picklist Print

December-21-11 3:43:05 PM

Page 1

Work Order ID: 77830

77830

Parent Item: D3183-045

D3183-045

Parent Item Name: Bearing Assembly

Start Date: 21/12/2011

Required Date: 05/01/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3183-5		Manufactured	No			110	Each	46.0000	1	30			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3183-5

Bearing

**

12/01/16

Location

Loc Qty

Loc Code

ST236

46

74851

16

76205

30

30

MDEL RINR1.000

Purchased

No

130

f

65.3995

0.0333

1.051579

MDFI RINR1 000

Delrin Round Bar 1"

**

1.254

12/01/11

Location

Loc Qty

Loc Code

MAT055

65.3995

117985

0.407

118257

6.502

118392

10.4905

119306

48

1.254

Dart Aerospace Ltd

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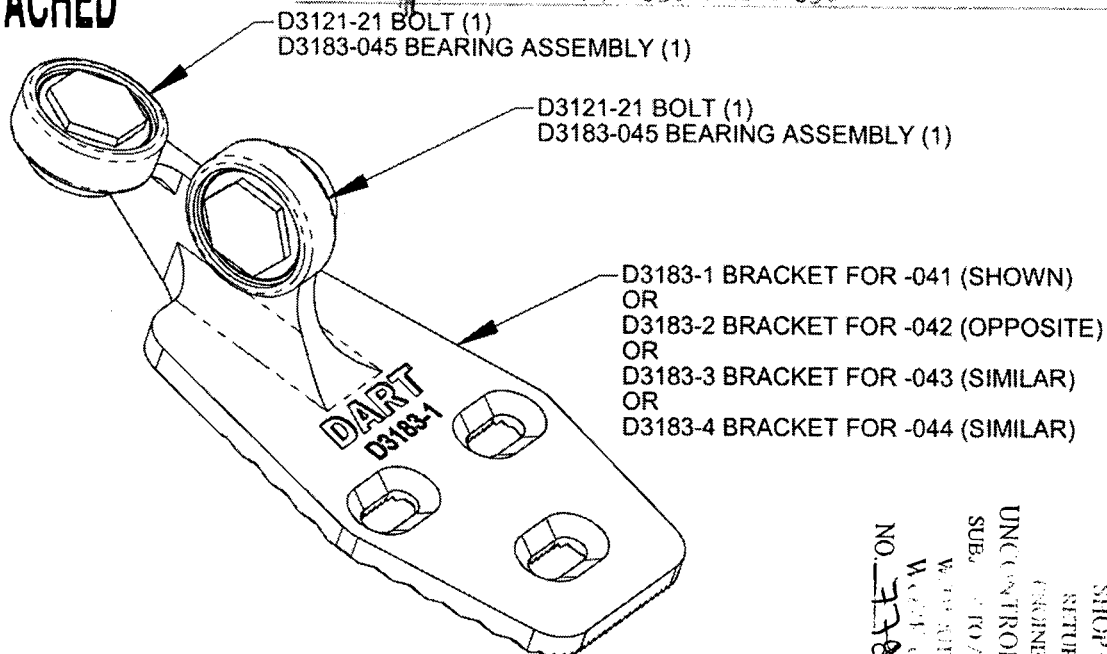
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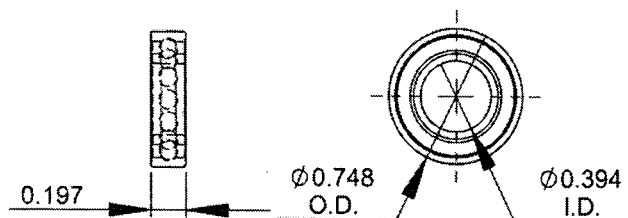
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04 03 01
DEO ATTACHED



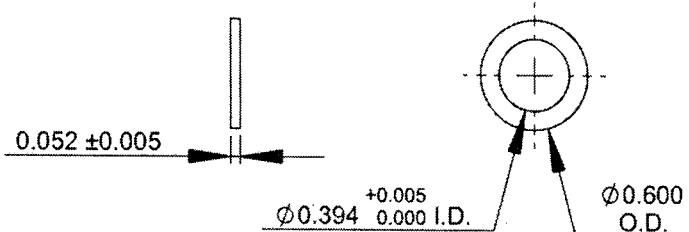
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUB. TO ATTACHMENT
W/OUT ORDER
NO. 77830 H.C.J.
11/2/22



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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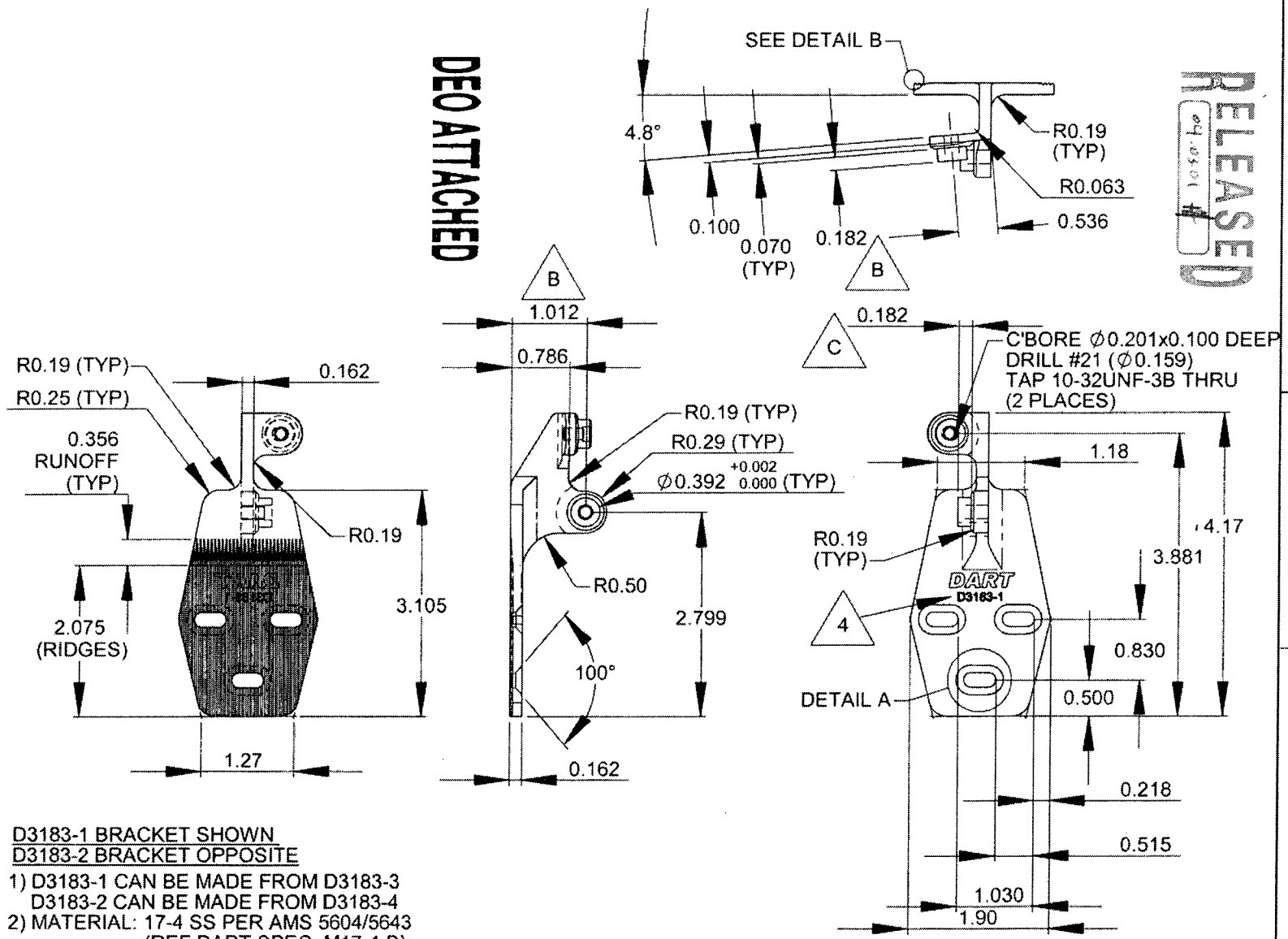
DART

DA COS
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		REV. C
		SHEET 2 OF 4
		SCALE 1:2

RELEASED
04-03-01

DEO ATTACHED



- D3183-1 BRACKET SHOWN**
D3183-2 BRACKET OPPOSITE
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
 - 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 4) ENGRAVE DART P/N & LOGO AS SHOWN
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

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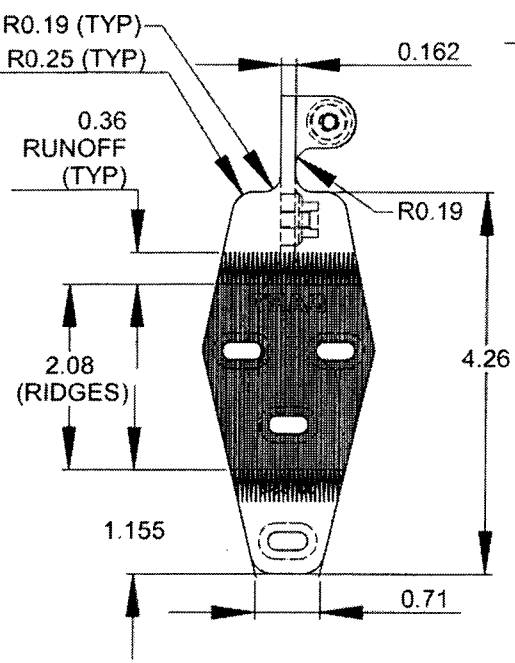
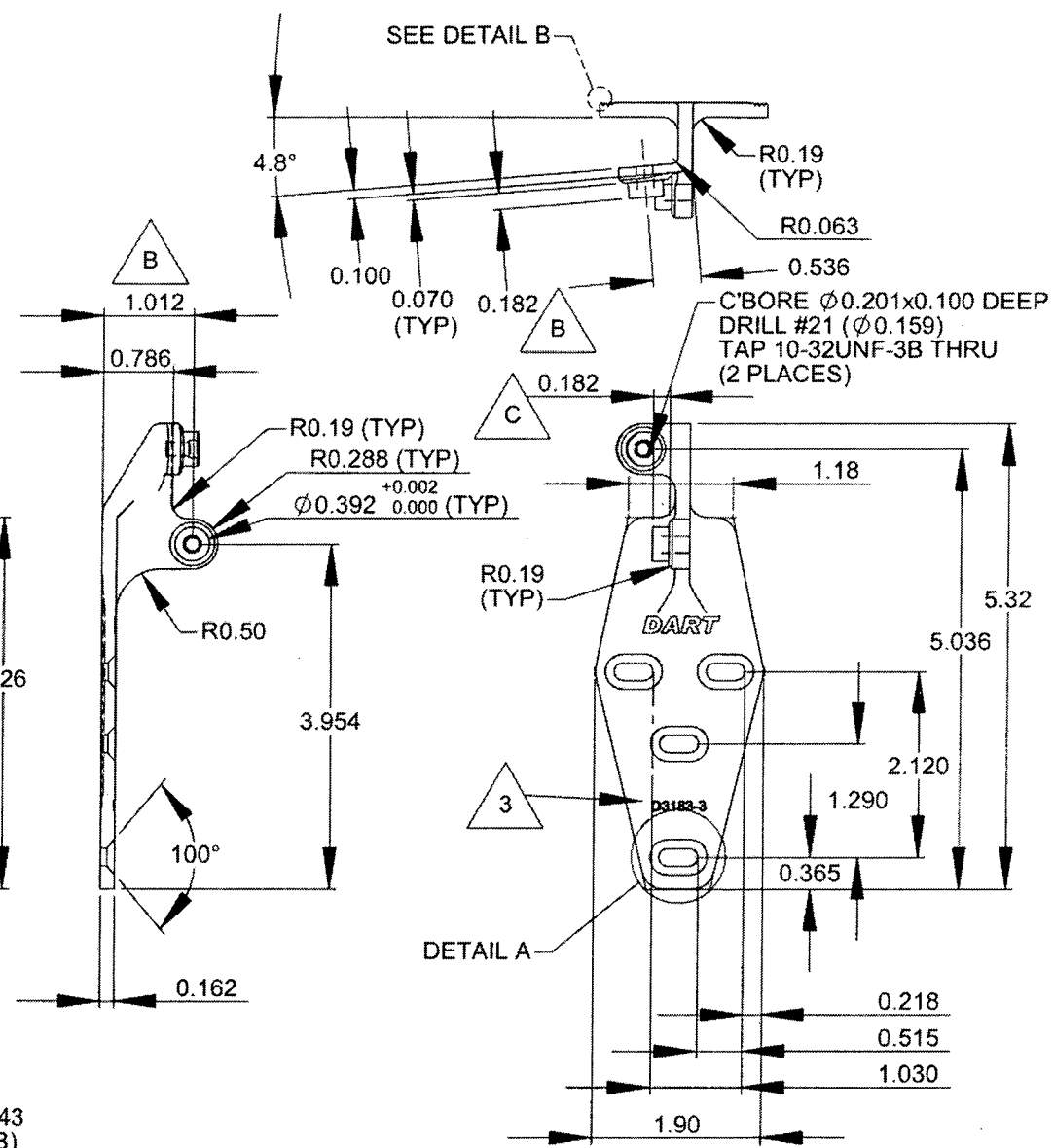
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
04.02.17	D3183	SHEET 3 OF 4
	BRACKET ASSEMBLY	SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DEO ATTACHED
RELEASED

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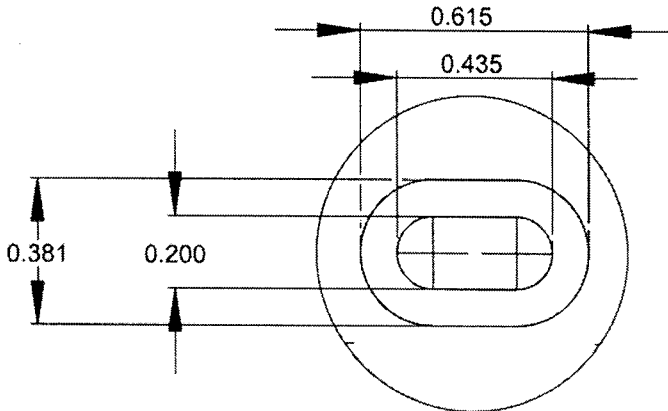
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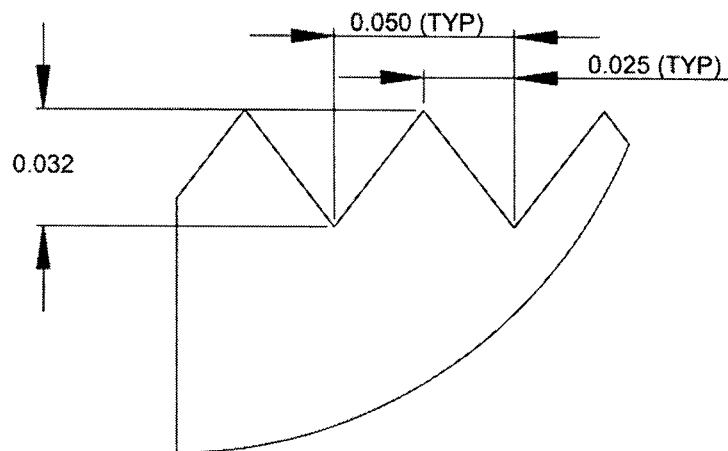
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



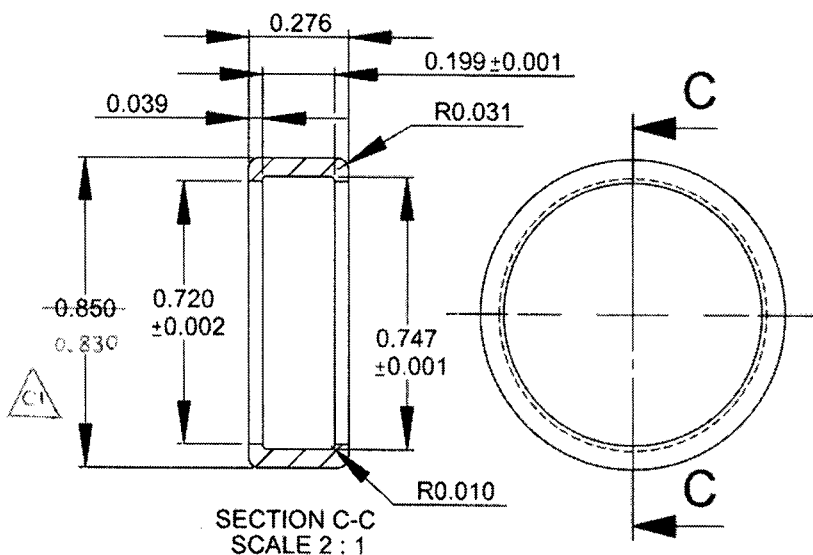
DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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Dart Aerospace Ltd

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED J	MFG. APPR. M	APPROVED MP		DE APPR. H		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
MP

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